

Work Order ID 84701

84701

Page 1

May-22-12 9:22:01 AM

Item ID: D3391-025

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Tube Assembly

Start Date: 22/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 29/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/22 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3391 | I | | | | | | | | |

100

0.00

100

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599 Rev: & Dwg D3391 Rev:

scribe batch # on fwd end at 90 degree

12-5-31

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

12/05/31

111

0.00

111

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

INSPECT INSIDE BORE

12/05/29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 84701

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Page 2

May-22-12 9:22:01 AM

Item ID: D3391-025 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Tube Assembly
 Start Date: 22/05/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 29/05/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | | 0.00 | | | | | | | |
| *120* | HAAS CNC VERTICAL MACHINING #1 | | | | | | | | |
| HAAS I | Memo | 0.00 | | | | | | | |
| HAAS CNC vertical machine #1 | 1-Machine as per Folio FA 599 Rev: <u>BA</u> & Dwg D3391 Rev: <u>I</u> 2-Deburr | | | | | | | | |
| 130 | | 0.00 | | | | | | | |
| *130* | QC2- Inspect parts off machine FAI/FAIB | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 140 | | 0.00 | | | | | | | |
| *140* | QC8- Inspect parts - second check | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | ***INSPECT INSIDE BORE*** | | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

May-22-12 9:22:01 AM

84701

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 22/05/2012 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 29/05/2012 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

150

0.00

150

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

160

0.00

160

BENDING MACHINE - SKIDTUBES

0.00

CNC Bend 1

Memo

CNC Delta 100 Bender

Form as per Dwg D3391 Using Bend Prog 3391025

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

4.13'

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 84701***84701***

Page 4

May-22-12 9:22:01 AM

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Tube Assembly
Start Date: 22/05/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 29/05/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180 | | 0.00 | | | | | | | |
| *180* | Skidtubes | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1-Open Aft cap pilot hole to .208" as per Dwg D3391 | | | | | | | | |
| | 2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only. | | | | | | | | |
| | 3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig. *****Do Not Open To Finished Size***** | | | | | | | | |
| | 4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes. | | | | | | | | |
| | 5-Open wearplate holes to 0.250" and c'bore as per dwg D3391 | | | | | | | | |
| | 6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391. | | | | | | | | |
| | 7-Deburr | | | | | | | | |

CF 12.6-4

De 12/06/11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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84701

Page 5

May-22-12 9:22:01 AM

Item ID: D3391-025 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Tube Assembly
 Start Date: 22/05/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 29/05/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|----------------------------------------------|-----------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 190 *190* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | | | | |
| 200 *200* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | | | | 7/6 12-6-12 |
| 210 *210* QC Quality Control | QC7-Inspect Chemical Conversion Coat Memo | 0.00 0.00 | | | | | | | ① 12/06/12 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 84701

84701

Page 6

May-22-12 9:22:01 AM

Item ID: D3391-025 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Tube Assembly
 Start Date: 22/05/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 29/05/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|-----------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 220 | Skidtubes | 0.00 | | | | | | | |
| *220* | Memo | 0.00 | | | | | | | |
| Skidtubes | Instal spacers as per dwg D3391 | | | | | | | | |
| Skidtubes | A/R Magnabond 6398 Batch: M120666 | | | | | | | | |
| | exp. date: 13/01/30 | | | | | | | | |
| | cure time 12hrs as per QSI0015 | | | | | | | | |
| 230 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *230* | Memo | 0.00 | | | | | | | |
| QC | | | | | | | | | |
| Quality Control | | | | | | | | | |
| 235 | Pressure Wash per QSI005 4.3 | 0.00 | | | | | | | |
| *235* | Memo | 0.00 | | | | | | | |
| HandFinish | AND REALODINE AS PER PAR09-043 | | | | | | | | |
| Hand Finishing | | | | | | | | | |

DC 12/06/12

5/12/06/13

1 11/12-6-13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 84701

84701

Page 7

Item ID: D3391-025

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Aft Tube Assembly

Stop *NS2*

Start Date: 22/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 29/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|----------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 240 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| *240* | | | | | | | | | |
| Powdercoat | | | | | | | | | |
| Powder Coating | | | | | | | | | |
| | Memo | | | | | | | | |
| | START TIME: 8:20 | 0.00 | | | | | | | |
| | OVEN TEMPERATURE: 320 °F | | | | | | | | |
| | FINISH TIME: 8:50 | | | | | | | | |
| 250 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *250* | | | | | | | | | |
| QC | | | | | | | | | |
| Quality Control | | | | | | | | | |
| | Memo | | | | | | | | |
| 260 | | 0.00 | | | | | | | |
| *260* | HandFinishing | | | | | | | | |
| HandFinish | | | | | | | | | |
| Hand Finishing | | | | | | | | | |
| | Memo | | | | | | | | |
| | 1-Install inserts as per Dwg D3391 | | | | | | | | |
| | 2-Install Aft Cap as per Dwg D3391 | | | | | | | | |
| | A/ R Sikaflex-241/-291 11121409 | | | | | | | | |
| | Sikaflex expiry date: 1303 | | | | | | | | |
| | 3- INSTALL WEARPLATES AS PER DWG | | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 84701

84701

Page 8

May-22-12 9:22:01 AM

Item ID: D3391-025 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Tube Assembly
 Start Date: 22/05/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 29/05/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|----------------------------------------|-------------------------------------------------------------|----------------------|---------|-----------|--------------|---------------|---------------|------------------|--------------------------|
| 270 *270* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | 8760127 | | | | | |
| 280 *280* Packaging Packaging | Identify as per dwg & Stock Location: <u>FP</u> Memo | 0.00 0.00 | | ME 120627 | | | | | |
| 290 *290* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | 12/6/28 97 ME 1206-27 |

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

May-22-12 9:22:06 AM

Page 1

Work Order ID: 84701

84701

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 22/05/2012

Required Date: 29/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H
 11.11.14 AS PER REV.I DD verified by:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D4095-047

Manufactured No

260

Each

11.0000

1

1

D4095-047

Wearpad Assembly

**

HL 12/06/19

Location

Loc Qty

Loc Code

FP002

11

81626

11

X1

D4095-049

Manufactured No

260

Each

19.0000

1

1

D4095-049

Wearpad Assembly

**

HL 12/06/19

Location

Loc Qty

Loc Code

FP002

19

81612

19

X1

D6014-090

Manufactured No

100

Each

68.0000

1

1

D6014-090

ALUMINUM EXTRUSION

**

Location

Loc Qty

Loc Code

LG

68

77332

26

79742

42

① KC 12-6-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

May-22-12 9:22:07 AM

Page 2

Work Order ID: 84701

84701

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 22/05/2012

Required Date: 29/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

85.0000

4

4

D3670-4-200

SPACER

**

DL 12/06/12

Location *274504*

Loc Qty

Loc Code

LG

40

80360

40

LG001

45

78606

4

81972

41

(4)

D2646

Manufactured No

270

Each

35.0000

1

1

D2646

Aft Cap

**

HL 12/06/12

Location

Loc Qty

Loc Code

FP002

35

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

78018

5

79562

14

X1

D3672-1

Manufactured No

270

Each

1,206.000

2

2

D3672-1

Phenolic Washer

**

HL 12/06/12

Location

Loc Qty

Loc Code

ST060

1206

72229

4

76277

202

80369

500

83608

500

X2

May-22-12 9:22:07 AM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

May-22-12 9:22:07 AM

Page 3

Work Order ID: 84701

84701

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 22/05/2012

Required Date: 29/05/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

260

Each

3,253.000

14

14

AI S4-1032-130

Insert

**

HL 12/06/19

Location

Loc Qty

Loc Code

ST280

205

119084

116

120671

89

ST281

174

120807

36

120837

138

ST282

2874

121269

2874

V14

ALS4-1032-225

Purchased

No

270

Each

888.0000

8

8

AI S4-1032-225

Insert

**

HL 12/06/19

Location

Loc Qty

Loc Code

ST281

865

108696

146

110768

62

118386

55

118966

68

121269

534

V 8

ST282

23

120410

10

120451

13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

May-22-12 9:22:07 AM

Page 4

Work Order ID: 84701

84701

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 22/05/2012

Required Date: 29/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

270

Each

1,941.000

6

6

AN3C4A

BOLT

**

11 n/a

Location

Loc Qty

Loc Code

ST350

1941

120187

57

120521

28

120769

38

121205

1000

121556

818

12

AN3C5A

Purchased

No

270

Each

1,348.000

4

4

AN3C5A

Bolt

**

11 n/a

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1341

116419

28

117343

13

117764

7

117872

2

119749

23

120423

28

121068

12

121255

500

121444

228

121708

500

12

AN960C10L

NAS1149C0332

Purchased

No

270

Each

0.0000

10

10

*AN960C10I *

washer

1122063

**

10/11 n/a

May-22-12 9:22:07 AM

Shop Packet Print

Page 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | |
|------------------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 84701 |
| Description: Float Skidtube (412) | | Part Number: D3391-3 |
| Inspection Dwg: D3391 | Rev: I | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|--------------------|-----------|------------------|--------|--------|----------------------|----------|
| Lathe Section | | | | | | |
| 14.000 | +/-0.010 | 14.000 | ✓ | | | |
| 3.500 | +/-0.010 | 3.502 | ✓ | | | |
| 88.93 | +/-0.030 | 88.96 | ✓ | | | |
| Ø3.200 | +/-0.010 | 3.200 | ✓ | | | |
| 88.93 | +/-0.030 | 88.96 | ✓ | | | |
| Ø3.750 | +/-0.010 | 3.750 | ✓ | | | |
| 30° x 160" chamfer | +/-0.010 | 30 x 160 | ✓ | | | |

| | |
|-------------------------|-----------------------|
| Measured by: MML | Date: 12-5-23 |
| Audited by: B.A. | Date: 12/05/29 |

| | | | | | | |
|--------------|---------------|--------|---|--|------|--------|
| HAAS Section | | | | | | |
| 1.526 | +0.000/-0.030 | 1.520 | ✓ | | Mic | GA-10 |
| 7.500 | +/-0.010 | 7.500 | ✓ | | Vern | CNC-02 |
| 27.750 | +/-0.010 | 27.750 | ✓ | | TAPE | GA-12 |
| 31.750 | +/-0.010 | 31.750 | ✓ | | " | " |
| 35.250 | +/-0.010 | 35.250 | ✓ | | " | " |
| 3.300 | +/-0.010 | 3.310 | ✓ | | Vern | GA-01 |
| 0.200 | +/-0.010 | 0.200 | ✓ | | " | " |
| 3.520 | +/-0.010 | 3.520 | ✓ | | " | " |
| 0.687 | +0.010/-0.000 | 0.687 | ✓ | | " | " |
| R0.062 | +/-0.010 | R0.062 | ✓ | | R-G | ref. |
| Ø0.484 | +0.005/-0.001 | Ø0.489 | ✓ | | Vern | GA-01 |

| | |
|-----------------------------------|----------------------|
| Measured by: B.A. 12/05/29 | Date: 12-5-23 |
| Audited by: B.A. | Date: 12-5-29 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------------------------------------|------------|----------|
| A | 06.04.24 | New Issue P/O D3391-015/-025 | KJ/JLM | |
| B | 06.06.19 | Dwg revision update | KJ/JLM | |
| C | 07.04.20 | Ø0.208 dimension removed | KJ/JLM | |
| D | 07.09.06 | 0.400 dimension removed | KJ/JLM | |
| E | 07.11.23 | Dwg Rev. updated | KJ/EC/DD | |
| F | 09.04.27 | Dimensions updated per Rev H and NCR09-028 | KJ/JLM | |
| G | 09.11.16 | Dimension 0.200 removed | KJ | |
| H | 11.06.21 | Dimension 44.995 removed | KJ | |
| I | 12.05.15 | Dwg Rev updated | KJ | |

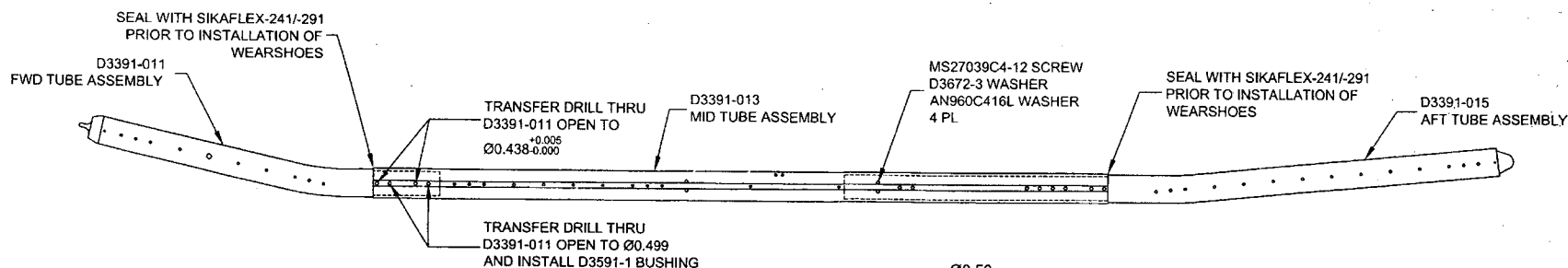
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes, No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action > Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

| QTY -041 | PART NUMBER | DESCRIPTION |
|-------------|--------------|-------------------------|
| X | D3391-041 | FLOAT SKIDTUBE ASSEMBLY |
| 1 | D3391-011 | FWD TUBE ASSEMBLY |
| 1 | D3391-013 | MID TUBE ASSEMBLY |
| 1 | D3391-015 | AFT TUBE ASSEMBLY |
| 2 | D3591-1 | BUSHING |
| 4 | D3672-3 | WASHER |
| 1 | D4095-041 | WEARSHOE |
| 1 | D4095-043 | WEARSHOE |
| 1 | D4095-045 | WEARSHOE |
| 1 | D4095-047 | WEARPAD |
| 1 | D4095-049 | WEARPAD |
| 1 | D4095-051 | WEARSHOE |
| 24 | AN3C4A | BOLT |
| 10 | AN3C6A | BOLT |
| 4 | AN3C7A | BOLT |
| 38 | AN960C10L | WASHER |
| 4 | MS27039C4-12 | SCREW |
| 4 | AN960C416L | WASHER |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84701 *MLJ*
12/05/22

D3391-041 ASSEMBLY

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

RELEASED
2011-11-04
ECN# 11-662

| | | | |
|------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| I | REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8 | XDF | 11.10.13 |
| H | DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE OSI 9364 & NCR 08-074) | AJS | 08.08.20 |
| G | REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY | DC | 07.07.31 |
| F | ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011-021 | PH | 07.01.16 |
| E | CHANGE TOLERANCE, EASE MANUFACTURE | PH | 06.04.25 |
| D | UPDATE TOLERANCE, CHANGE HOLE SIZE | PH | 06.01.23 |
| C | LENGTHEN AFT EXTENSION | PH | 05.09.27 |
| B | DRAWING UPDATES | PH | 05.06.10 |
| A | NEW ISSUE | PH | 05.02.07 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | PH | DART AEROSPACE USA, INC | |
| DRAWN | XDF | KENT, WA | |
| CHECKED | | DRAWING NO. | REV. 1 |
| MFG. APPR. | | D3391 | SHEET 1 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 412 FLOAT SKIDTUBE | NTS |
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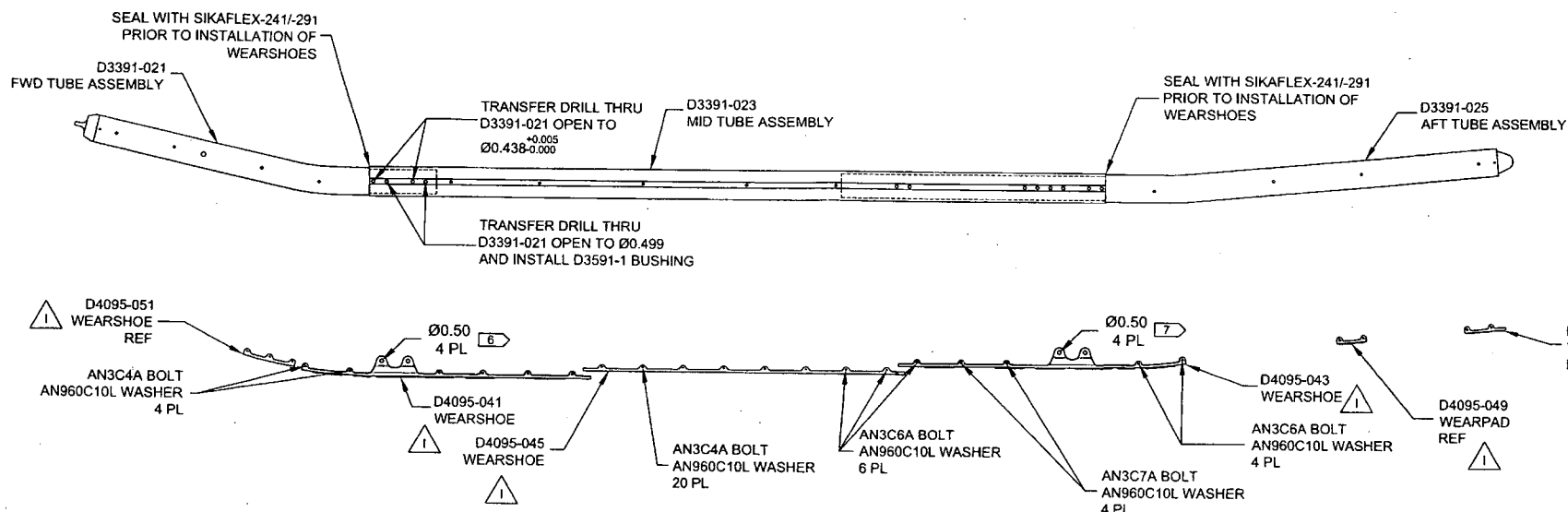
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries







D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

| QTY -043 | PART NUMBER | DESCRIPTION |
|----------|-------------|-------------------------|
| X | D3391-043 | FLOAT SKIDTUBE ASSEMBLY |
| 1 | D3391-021 | FWD TUBE ASSEMBLY |
| 1 | D3391-023 | MID TUBE ASSEMBLY |
| 1 | D3391-025 | AFT TUBE ASSEMBLY |
| 2 | D3591-1 | BUSHING |
| 1 | D4095-041 | WEARSHOE |
| 1 | D4095-043 | WEARSHOE |
| 1 | D4095-045 | WEARSHOE |
| 1 | D4095-047 | WEARSHOE |
| 1 | D4095-049 | WEARPAD |
| 1 | D4095-051 | WEARSHOE |
| 24 | AN3C4A | BOLT |
| 10 | AN3C6A | BOLT |
| 4 | AN3C7A | BOLT |
| 38 | AN960C10L | WASHER |

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL 0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL 0.50 HOLES FROM SADDLE TO D4095-043

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2011-11-04

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|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|---------------------------------------------|--------------|
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| MFG. APPR. |  | D3391 | SHEET 2 OF 8 |
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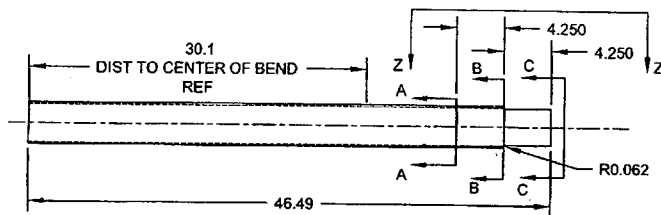
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

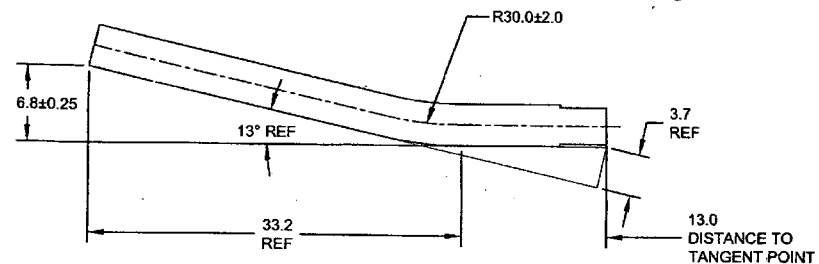
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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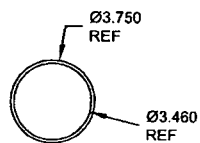
NOTE: Date & initial all entries



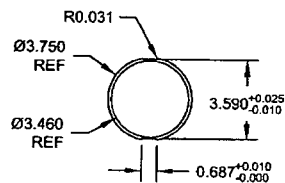
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



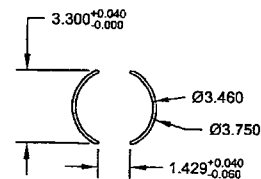
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



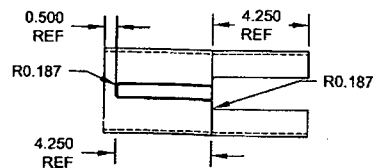
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

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| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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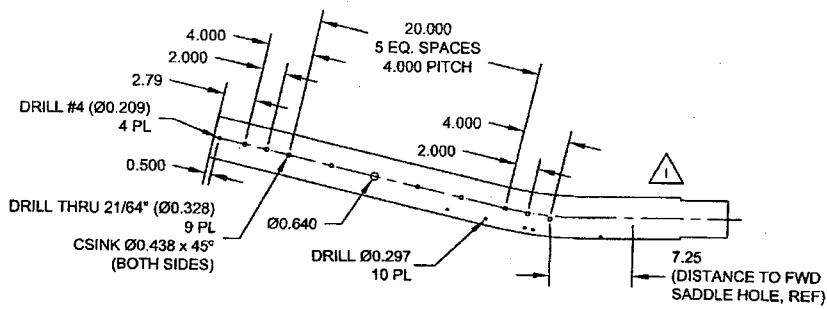
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

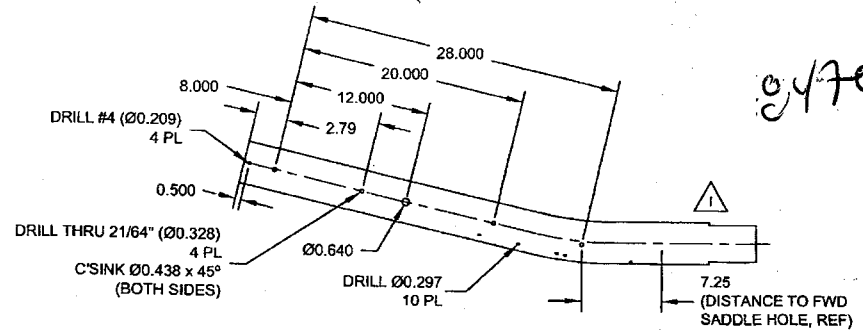
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|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

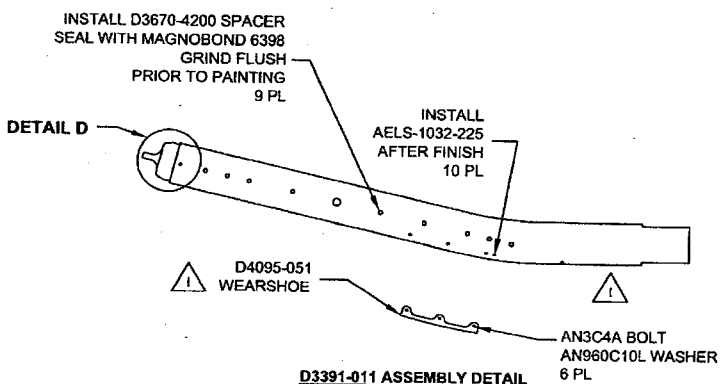
04701



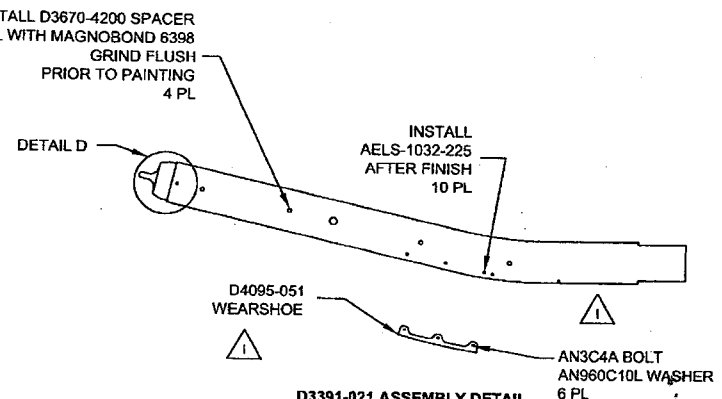
D3391-011 DRILLING DETAIL



D3391-021 DRILLING DETAIL



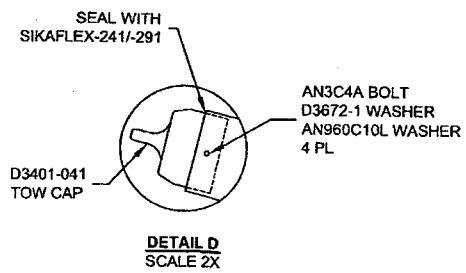
D3391-011 ASSEMBLY DETAIL



D3391-021 ASSEMBLY DETAIL

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

| QTY - 011 | QTY - 021 | PART NUMBER | DESCRIPTION |
|-----------|-----------|---------------|-------------------|
| X | X | D3391-011 | FWD TUBE ASSEMBLY |
| | | D3391-021 | FWD TUBE ASSEMBLY |
| 1 | 1 | D3401-041 | TOW CAP |
| 9 | 4 | D3670-4200 | SPACER |
| 4 | 4 | D3672-1 | WASHER |
| 1 | 1 | D4095-051 | WEARSHOE |
| 1 | 1 | D6013-047 | FWD TUBE |
| 10 | 10 | AN3C4A | BOLT |
| 10 | 10 | AN960C10L | WASHER |
| 10 | 10 | AELS-1032-225 | INSERT |



**DETAIL D
SCALE 2X**

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

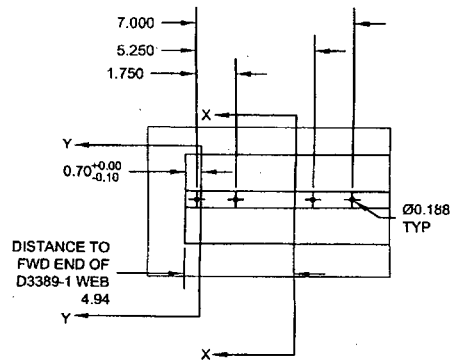
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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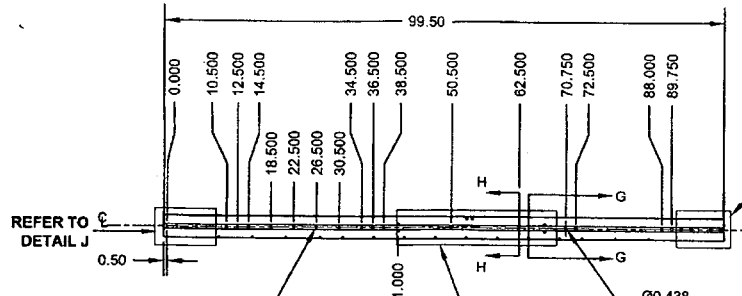
NOTE: Date & initial all entries

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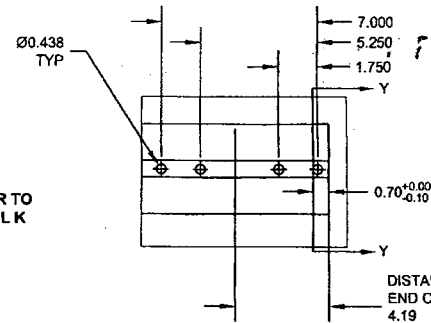


DETAIL J
SCALE 4X

DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



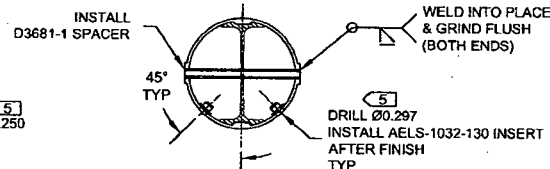
D3391-013 ASSEMBLY DETAIL



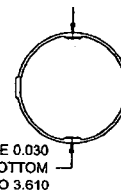
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SCALE 4X



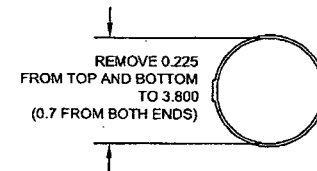
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



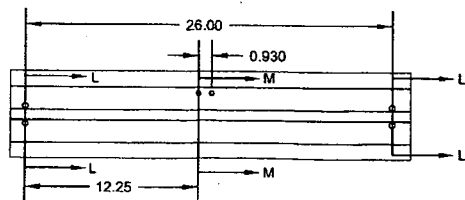
SECTION X-X
SCALE 5X



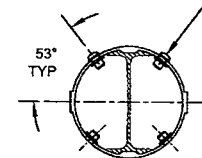
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

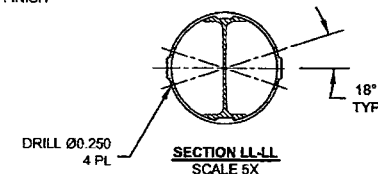
| QTY | PART NUMBER | DESCRIPTION |
|-----|---------------|-------------------|
| X | D3391-013 | MID TUBE ASSEMBLY |
| 1 | D2500-1-100 | EXTRUSION |
| 1 | D3389-1 | WEB |
| 4 | D3672-1 | WASHER |
| 4 | D3672-3 | WASHER |
| 12 | D3681-1 | SPACER |
| 24 | AELS-1032-130 | INSERT |
| 4 | ALS4-428-165 | INSERT |
| 4 | AN960C10L | WASHER |
| 4 | AN960C416L | WASHER |
| 4 | MS27039C1-09 | SCREW |
| 4 | MS27039C4-08 | SCREW |



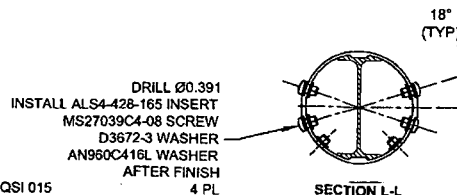
DETAIL E
SCALE NONE



SECTION M-M
SCALE 5X



SECTION LL-LL
SCALE 5X



SECTION L-L
SCALE 5X

D3391-013 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004

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2011-11-04

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| DRAWN | XOF | KENT, WA | |
| CHECKED | | DRAWING NO. | REV. 1 |
| MFG. APPR. | | D3391 | SHEET 5 OF 8 |
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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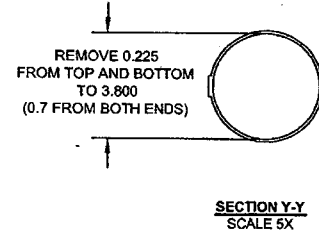
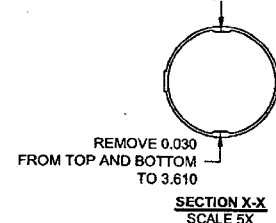
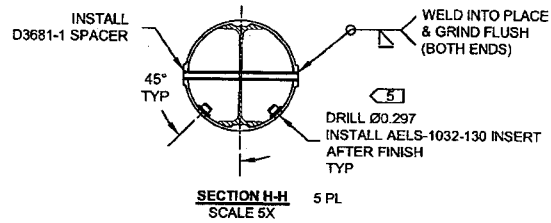
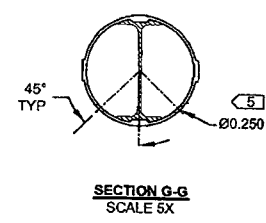
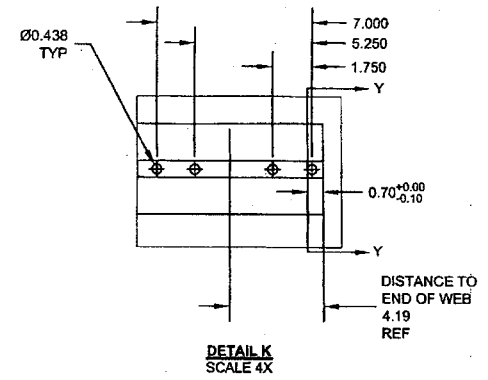
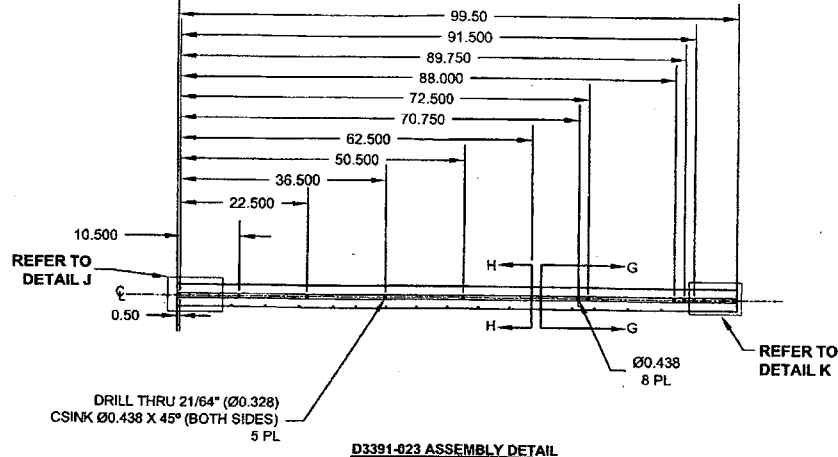
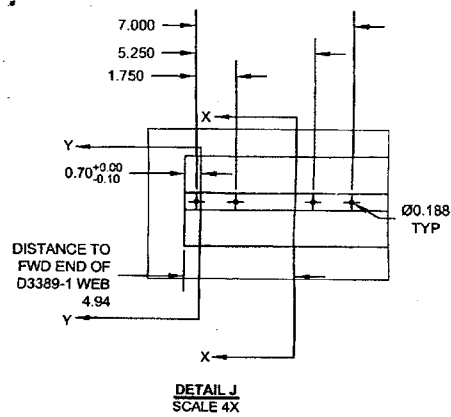
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

24701



D3391-023 MID TUBE ASSEMBLY PARTS LIST

| QTY - 023 | PART NUMBER | DESCRIPTION |
|-----------|---------------|-------------------|
| X | D3391-023 | MID TUBE ASSEMBLY |
| 1 | D2500-1-100 | EXTRUSION |
| 1 | D3389-1 | WEB |
| 5 | D3681-1 | SPACER |
| 20 | AELS-1032-130 | INSERT |

- D3391-023 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
 - 3) WELDING: PER DART QSI 004

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| DESIGN | PH | DRAWING NO. REV. 1 D3391 SHEET 6 OF 8 |
| DRAWN | XDF | |
| CHECKED | | TITLE SCALE 412 FLOAT SKIDTUBE NTS |
| MFG. APPR. | | |
| APPROVED | | DATE 11.10.13 |
| DE APPR. | | |

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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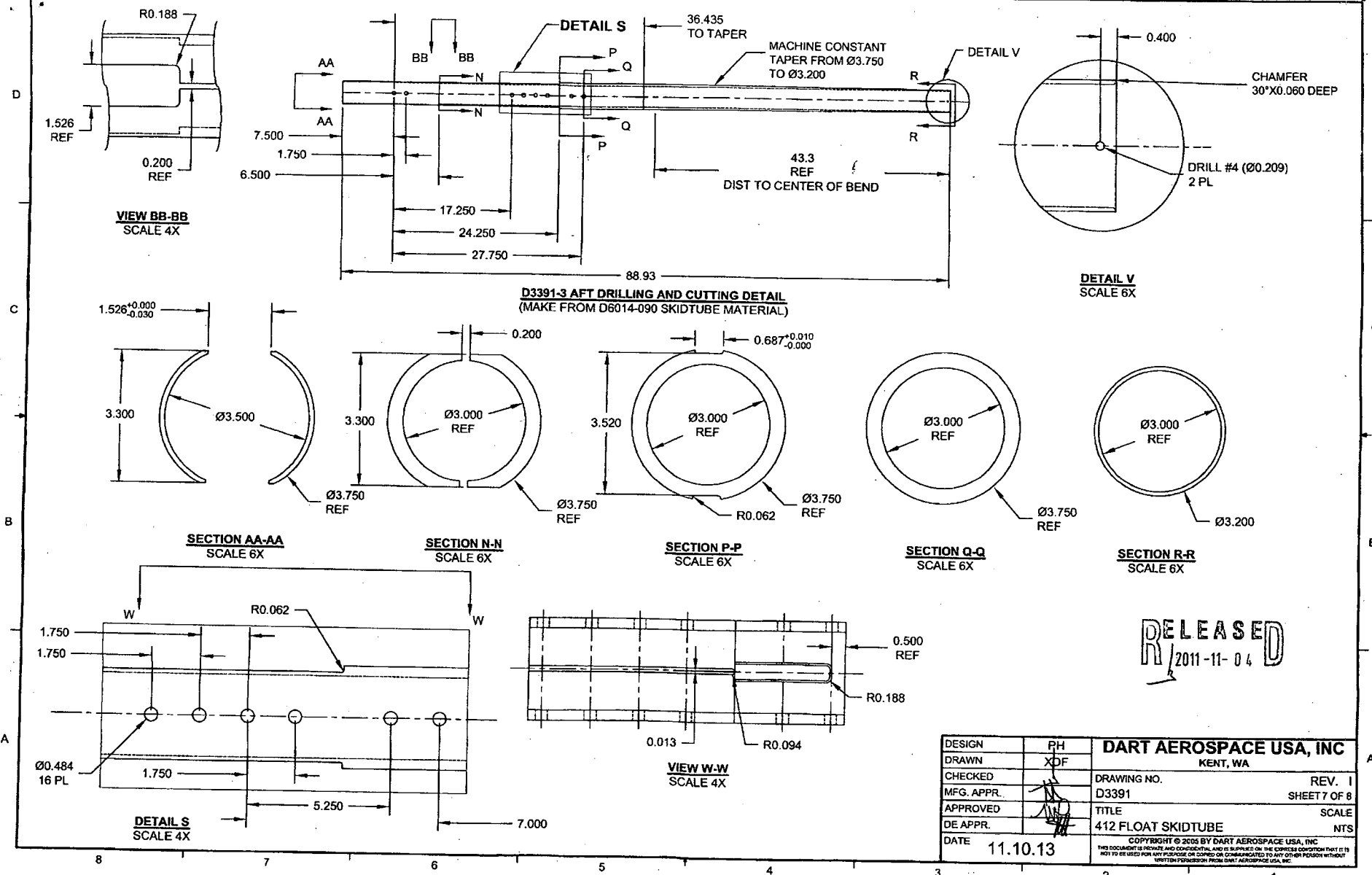
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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2011-11-04

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| DESIGN | RH | DART AEROSPACE USA, INC | |
| DRAWN | XDF | KENT, WA | |
| CHECKED | | DRAWING NO. D3391 | REV. I |
| MFG. APPR. | | | SHEET 7 OF 8 |
| APPROVED | | TITLE 412 FLOAT SKIDTUBE | SCALE |
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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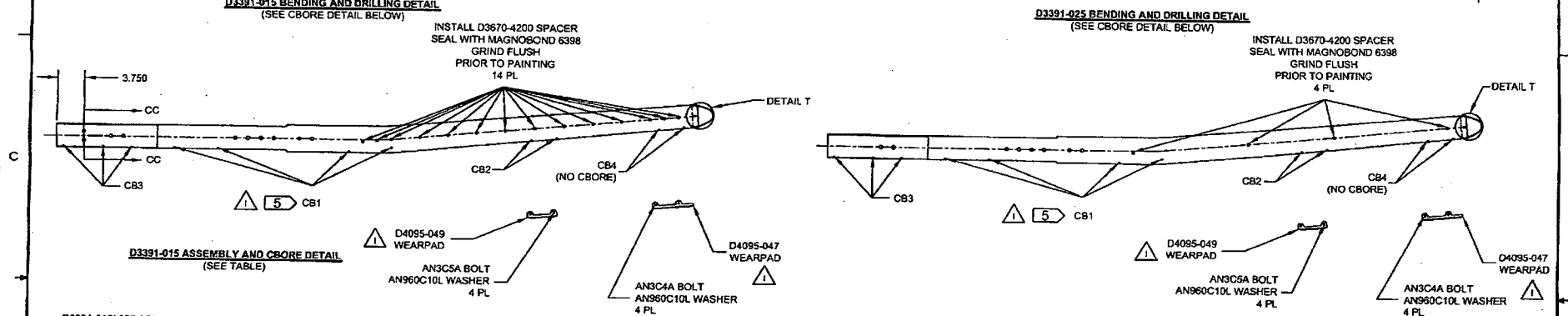
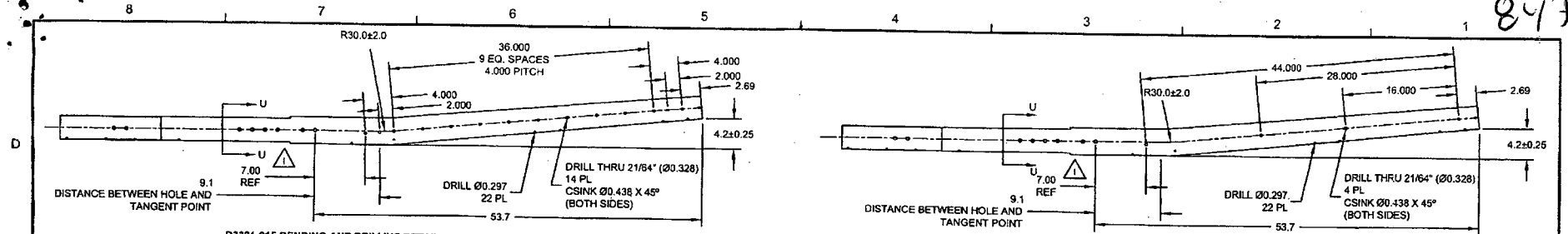
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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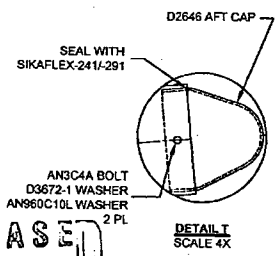
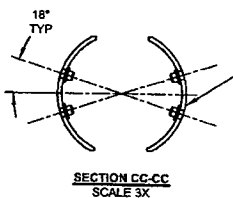
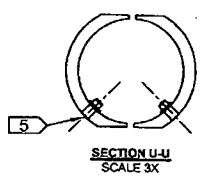
NOTE: Date & initial all entries

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D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

| QTY - 015 | QTY - 025 | PART NUMBER | DESCRIPTION |
|-----------|-----------|---------------|-------------------|
| X | X | D3391-015 | AFT TUBE ASSEMBLY |
| | | D3391-025 | AFT TUBE ASSEMBLY |
| 1 | 1 | D2646 | AFT CAP |
| 14 | 4 | D3670-4200 | SPACER |
| 2 | 2 | D3672-1 | WASHER |
| 1 | 1 | D4095-049 | WEARPAD |
| 1 | 1 | D4095-047 | WEARPAD |
| 1 | 1 | D6014-090 | AFT TUBE |
| 14 | 14 | AELS-1032-130 | INSERT |
| 8 | 8 | AELS-1032-225 | INSERT |
| 4 | 4 | ALS4-428-165 | INSERT |
| 6 | 6 | AN3C4A | BOLT |
| 4 | 4 | AN3C5A | BOLT |
| 10 | 10 | AN960C10L | WASHER |



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CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

| HOLES MARKED | QTY D3391-015 | QTY D3391-025 | CBORE | P/N |
|--------------|---------------|---------------|----------------|---------------|
| CB1 | 8 | 8 | Ø0.430 X 0.170 | AELS-1032-225 |
| CB2 | 4 | 4 | Ø0.430 X 0.170 | AELS-1032-130 |
| CB3 | 6 | 6 | Ø0.430 X 0.040 | AELS-1032-130 |
| CB4 | 4 | 4 | NONE | AELS-1032-130 |

| | | |
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| DRAWN | XOF | |
| CHECKED | | DRAWING NO. REV. 1 |
| MFG. APPR. | | D3391 SHEET 8 OF 8 |
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| DE APPR. | | 412 FLOAT SKIDTUBE NTS |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries